

## Hi-Dur PU100 Finish

<b>Product Description</b>	<b>A general purpose urethane-alkyd high gloss finish.</b>				
<b>Features &amp; Use</b>	<ul style="list-style-type: none"> <li>• Good gloss and gloss retention, with good weathering and durability</li> <li>• Can be applied by brush or spray</li> <li>• Fast air drying</li> <li>• Good resistance to chemical washing and chipping</li> <li>• May be used on agricultural machinery and earth moving equipment (ACE market), trailers and coach bodies and general metal fabrications</li> </ul>				
<b>Approvals/ Certification</b>	Please consult Axalta Coating Systems				
<b>Finish</b>	Gloss				
<b>Volume Solids</b>	44 ± 2% (varies with colour)				
<b>VOC Content</b>	448 ± 20 g/litre (varies with colour)				
<b>Film Thickness Range And Coverage</b>		<b>Dry Film Thickness</b>	<b>Wet Film Thickness</b>	<b>Theoretical Coverage</b>	
	<b>Minimum</b>	25 µm	57 µm	17.6 m <sup>2</sup> /litre	
	<b>Maximum</b>	40 µm	91 µm	11.0 m <sup>2</sup> /litre	
Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated					
<b>Drying Times</b>	Applied to 30 microns DFT	<b>+10°C</b>	<b>+23°C</b>	<b>+35°C</b>	
	<b>Dust Free</b>	2½ hr	1½ hr	1 hr	
	<b>Hard Dry</b>	9 hr	6 hr	4 hr	
	<b>Overcoating</b>	Minimum	14 hr	12 hr	8 hr
		Maximum	Indefinite* if surface is clean and sound		
<p>*See Product Notes Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation</p>					
<b>Colours</b>	BS, RAL and full shade range by in-can tinting				
<b>Product Code</b>	<b>02HPU</b>				
<b>SG</b>	0.92 kg/lt (varies with colour)				
<b>Storage Conditions</b>	Store in dry, cool conditions and protect from frost				
<b>Shelf Life</b>	Minimum 12 months if stored as above in unopened containers				
<b>Flash Point</b>	23°C – 60°C				



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<b>Surface Preparation</b>	<ul style="list-style-type: none"> <li>This product is a finish coat and should be applied over an appropriate primer and/or intermediate coat. Please consult Axalta Coating Systems for advice</li> <li>All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts, weld flux or other contamination</li> </ul>														
<b>Mixing</b>	Must be mixed thoroughly by using a mechanical agitator before use. Agitate periodically to ensure paint remains homogeneous.														
<b>Thinner</b>	No.3 Thinner		<b>Equipment Cleaner</b> No.3 Thinner												
<b>Application Conditions</b>	Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point. Paint temperature should ideally be at a minimum of 15°C.														
<b>Application Methods</b>	<table border="1"> <thead> <tr> <th data-bbox="421 824 673 898">Method</th> <th data-bbox="673 824 922 898">Airless Spray</th> <th data-bbox="922 824 1171 898">Conventional Spray</th> <th data-bbox="1171 824 1342 898">Brush</th> <th data-bbox="1342 824 1495 898">Roller</th> </tr> </thead> <tbody> <tr> <td data-bbox="421 898 673 954"></td> <td data-bbox="673 898 922 954">Yes</td> <td data-bbox="922 898 1171 954">Yes</td> <td data-bbox="1171 898 1342 954">Yes</td> <td data-bbox="1342 898 1495 954">Yes</td> </tr> </tbody> </table>					Method	Airless Spray	Conventional Spray	Brush	Roller		Yes	Yes	Yes	Yes
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	Yes	Yes	Yes	Yes											
<ul style="list-style-type: none"> <li>Airless Spray: Output fluid pressure at tip 2000 psi, Tip Size 11-15 thou (0.28-0.38 mm). Thinning up to 10% may be used if required</li> <li>Conventional spray: use 50-60 psi pressure, 1.4-1.8mm diameter nozzle. Thinning up to 15% may be used if required</li> <li>Brush/Roller – use as supplied. Thinning up to 5% may be used if required</li> </ul>															
<b>Product Notes</b>	<ul style="list-style-type: none"> <li>Maximum overcoating time is indefinite if clean and sound, but for best results overcoating within 48 hours (with itself, at 20°C) is recommended</li> <li>Two full coats are recommended for maximum opacity and protection</li> <li>Not recommended for immersion</li> <li>For best opacity use a primer or undercoat of a suitable shade</li> <li>Colours such as yellows, reds and oranges have lower opacity, especially when produced using lead-free pigments. Two or three coats of these shades may be required, relative to only one coat of a grey or red oxide</li> </ul>														
<b>Health &amp; Safety</b>	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.														

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